

# Work Order ID 115514

April-02-14 11:16:08 AM

**\*115514\***

Page 1

Item ID: D3391-025 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Aft Tube Assembly  
 Start Date: 4/02/14 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 4/16/14 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: MCS Date: 14-04-02 Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3391	I

100 0.00  
**\*100\*** MORI SEIKI CNC LATHE LARGE  
 Mori Seiki Memo 0.00  
 Mori Seiki CNC Lathe Large Turn as per Folio FA599 Rev: AA & Dwg D3391 Rev: 4  
 \*\*\*\*REMOVE STEADY REST AND MACHINIG MARKS\*\*\*\*

110 0.00  
**\*110\*** QC2- Inspect parts off machine FAI/FAIB  
 QC Memo 0.00  
 Quality Control

112 0.00  
**\*112\*** QC5- Inspect part completeness to step on W/O  
 QC Memo 0.00  
 Quality Control

1 0 mmL KE  
14-04-03  
mmL  
14/04/05

THP  
4/4/23

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Item ID: D3391-025

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Aft Tube Assembly

Start Date: 4/02/14

Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 4/16/14

Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

**\*120\***

HAAS 1

HAAS CNC VERTICAL MACHINING #1

0.00

*aml 14/04/27*10

DAS

14

9-89

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA 599 Rev: AA & Dwg D3391 Rev: I  
2-Deburr

130

**\*130\***

QC

QC2- Inspect parts off machine FAI/FAIB

0.00

*aml 14/04/27*10

DAS

14

9-89

Memo

0.00

Quality Control

140

**\*140\***

QC

QC8- Inspect parts - second check

0.00

10

DAS

44

9-89

*14/04/28*

Memo

0.00

Quality Control

\*\*\*INSPECT INSIDE BORE\*\*\*

SAC  
AT  
7-2

SAC  
AT  
6-2

SAC  
AT  
1-1

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
<b>*150*</b>	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803								
160		0.00							
<b>*160*</b>	BENDING MACHINE - SKIDTUBES								
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	Form as per Dwg D3391 Using Bend Prog 3391025								
170		0.00							
<b>*170*</b>	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

H-4.16

DAS  
03  
9-89

DP 14-4-29

1951

1952

1953

1954

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Item ID: D3391-025

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Aft Tube Assembly

Start Date: 4/02/14 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 4/16/14 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

0.00

\*180\*

Skidtubes

0.00

Skidtubes

Memo

Skidtubes

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217  
Wearplate Jig .

\*\*\*\*\*Do Not Open To Finished Size\*\*\*\*\*

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2  
previously drilled aft wearplate holes.

5-Open wearplate holes to 0.297" and c'bore as per dwg D3391

6-Open up all float bag holes to 0.328" and c'sink as per Dwg D3391.

7-Deburr

8- Scribe batch # on fwd end

DL 14/05/13

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## Quality Control

Shaf  
14/5/14

22 14/05/14

14-5-14

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Required Date: 4/16/14 Req'd Qty: 1.00 **\*1\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	Skidtubes	0.00							
<b>*220*</b>									
Skidtubes	Memo	0.00							
Skidtubes	1- Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: <u>129172</u> exp. date : <u>14/12/30</u> cure time 12hrs as per QSI0015								
	2- Grind crossbolts flush								
	3- Back drill using #9 drill								
	4- Touchup Magnabond								
	5- Deburr								
230	QC5- Inspect part completeness to step on W/O	0.00							
<b>*230*</b>									
QC	Memo	0.00							
Quality Control									

DC 14/05/14

DC 14/05/15

SH  
14/5/15



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 Required Date: 4/16/14 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
235	Pressure Wash per QSI005 4.3	0.00							
<b>*235*</b>	HandFinish	0.00							
Hand Finishing	Memo AND REALODINE AS PER PAR09-043								
240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*240*</b>	Powdercoat	0.00							
Powder Coating	Memo START TIME: 10:15 OVEN TEMPERATURE: 320 FINISH TIME: 0:45								
250	QC3- Inspect Part Finish	0.00							
<b>*250*</b>	QC	0.00							
Quality Control	Memo								

DAS 34 9-89

DAS 15 9-89

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 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260		0.00							
<b>*260*</b>	HandFinishing					1x	d	90	4/07
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts as per Dwg D3391								
	2-Install Aft Cap as per Dwg D3391								
	A/ R Sikaflex-241/-291 1179457								
	Sikaflex expiry date: 1411								
	3- INSTALL WEARPLATES AS PER DWG								
270	QC5- Inspect part completeness to step on W/O	0.00							
<b>*270*</b>									
QC	Memo	0.00							
Quality Control									
280	Identify as per dwg & Stock Location: W/O	0.00							
<b>*280*</b>									
Packaging	Memo	0.00				1x	d	90	4/07
Packaging									

DAS  
27  
4-89

11/16

0412-742-043/B115491

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Item ID: D3391-025

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Aft Tube Assembly

Stop \*NS2\*

Start Date: 4/02/14

Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 4/16/14

Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

290

QC21- Final Inspection - Work Order Release

0.00

\*290\*

QC

Memo

0.00

Quality Control

MW 14-07-16

4-7-16

# Picklist Print

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Page 1

Work Order ID: 115514

\*115514\*

Parent Item: D3391-025

\*D3391-025\*

Parent Item Name: Aft Tube Assembly

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC  
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM  
 IPP rev D 07.03.20 revF dwg EC  
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD  
 IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC  
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC IPP Rev:H  
 11.11.14 AS PER REV.I DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4095-047		Manufactured	No			260	Each	18.0000	1	1			
*D4095-047*													
Wearpad Assembly													

Location	Loc Qty	Loc Code
FP001	18	
102241	2	
108289	16	

D4095-049		Manufactured	No			260	Each	13.0000	1	1			
*D4095-049*													
Wearpad Assembly													

Location	Loc Qty	Loc Code
FP001	12	
109670	12	
FP002	1	
102216	1	

D6014-090		Manufactured	No			100	Each	69.0000	1	1			
*D6014-090*													
ALUMINUM EXTRUSION													

Location	Loc Qty	Loc Code
LG003	69	
79742	17	
86063	52	

Handwritten notes and signatures:

- Under D4095-047: \*\* [Signature] 4/03/15
- Under D4095-049: \*\* [Signature] 4/03/15
- Under D6014-090: \*\* [Signature] 4/04/02

# Picklist Print

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Work Order ID: 115514

**\*115514\***

Parent Item: D3391-025

**\*D3391-025\***

Parent Item Name: Aft Tube Assembly

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No

230

Each

300.0000

4

4

**\*D3670-4-200\***

Bushing

**\*\***

DL 14/05/14

Location

Loc Qty

Loc Code

FG

10

87709

10

LG001

290

103880

39

109108

242

96240

9

D2646

Manufactured No

270

Each

75.0000

1

1

**\*D2646\***

Aft Cap

**\*\***

all 11/07/15

Location

Loc Qty

Loc Code

FG

4

85848

2

90495

2

FP001

71

103306

14

107857

1

110816

18

113830

38

XC

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Shop Packet Print

Page 2

# Picklist Print

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Work Order ID: 115514

**\*115514\***

Parent Item: D3391-025

**\*D3391-025\***

Parent Item Name: Aft Tube Assembly

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

270

Each

1,420.000

2

2

**\*D3672-1\***

Phenolic Washer

**\*\***

*ll 4/07/15*

Location

Loc Qty

Loc Code

FG	10	
85222	10	
ST060	1410	
103845	4	
112218	500	
113581	500	
93886	224	
<u>99099</u>	182	

*x2*

ALS4-1032-130

AELS4-1032-130 Purchased

No

260

Each

9,937.000

14

14

**\*AI S4-1032-130\***

Rivnut

**\*\***

*ll 4/07/15*

Location

Loc Qty

Loc Code

FP001	9832	
<u>M128649</u>	9832	
ST279	48	
M128211	48	
st510	57	
M126109	57	

*x14*

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Shop Packet Print

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# Picklist Print

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Work Order ID: 115514

**\*115514\***

Parent Item: D3391-025

**\*D3391-025\***

Parent Item Name: Aft Tube Assembly

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

AELS8-1032-225

Purchased

No

270

Each

1,490.000

8

8

**\*AI S4-1032-225\***

**\*\***

Rivnut

Location

Loc Qty

Loc Code

FG

30

M127028

30

FP001

1000

M128649

1000

ST280

426

M127028

10

M128179

416

st555

34

M127092

34

x8

AN3C4A

Purchased

No

270

Each

2,208.000

6

6

**\*AN3C4A\***

**\*\***

Bolt

Location

Loc Qty

Loc Code

FG

20

122814

20

ST350/513

1000

M128606

1000

ST512

3

124221

3

ST513

1185

125388

122

M127410

1

M127832

62

M128634

1000

1128879

x6

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# Picklist Print

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Work Order ID: 115514

**\*115514\***

Parent Item: D3391-025

**\*D3391-025\***

Parent Item Name: Aft Tube Assembly

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

270

Each

705.0000

4

4

**\*AN3C5A\***

Bolt

**\*\***

*all 4/07/15*

Location

Loc Qty

Loc Code

FG

5

M128911

*v4*

122800

5

ST350

700

M128057

700

NAS1149C0332R

Purchased

No

270

Each

9,644.000

10

10

**\*NAS1149C0332R\***

WASHER

**\*\***

*all 4/07/15*

Location

Loc Qty

Loc Code

GA

1005

M129499

*v10*

125654

1005

ST292

4968

m128591

4968

st510

3671

m126319

61

m127306

2500

m127410

1084

m127831

26

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Shop Packet Print

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DQA: \_\_\_\_\_ Date: \_\_\_\_\_



# **WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

## **FAULT CATEGORY**

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence  <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 115514
<b>Description:</b> Float Skidtube (412)		<b>Part Number:</b> D3391-3
<b>Inspection Dwg:</b> D3391	<b>Rev:</b> I	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.000	/			
3.500	+/-0.010	3.508	/			
Ø3.200	+/-0.010	3.203	/			
Ø3.750	+/-0.010	3.750	/			
30° x 0.060 chamfer	+/-0.010	30° x .060	/			
88.93	+/-0.030	88.93	/			

<b>Measured by:</b> <i>mmf</i>	<b>Date:</b> <i>11/04/06</i>
<b>Audited by:</b> <i>14/4/23</i>	<b>Date:</b> <i>14/4/23</i>

HAAS Section						
1.526	+0.000/-0.030	1.515	/		Vern	ML-06
7.500	+/-0.010	7.500	-		"	
27.750	+/-0.010	27.750	-		M-type	ML-08
31.750	+/-0.010	31.750	-		"	
35.250	+/-0.010	35.250	-		"	
3.300	+/-0.010	3.305	-		Vern	ML-06
0.200	+/-0.010	.200	-		"	
3.520	+/-0.010	3.515	-		"	
0.687	+0.010/-0.000	.6912	-		"	
R0.062	+/-0.010	R.062	-		R-G	
Ø0.484	+0.005/-0.001	Ø.485	-		Vern	ML-06

<b>Measured by:</b> <i>mmf</i>	<b>Date:</b> <i>14/04/22</i>
<b>Audited by:</b> <i>FL</i>	<b>Date:</b> <i>14/04/28</i>

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	
I	12.05.15	Dwg Rev updated	KJ	
J	12.05.23	Dimension updated	KJ	
K	12.10.15	88.93 dimension removed	KJ	
L	12.11.28	88.93 dimension added	KJ	





